

Debrin 75

Work Order ID 85612

85612

Page 1

June-12-12 8:49:39 AM

Item ID: D3396-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 12/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 12/06/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3396

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA514 and Dwg D3396Debur

DAS
14
2-89

12/07/29

38

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS
14
2-89

12/07/29

38

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

29 12-7-29

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85612

85612

Page 2

June-12-12 8:49:39 AM

Item ID: D3396-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacer

Stop *NS2*

Start Date: 12/06/2012 Start Qty: 20.00 *20*

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 20.00 *20*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>044</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/17/30 (38)

12/17/31 98

MCS 12/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 8:49:43 AM

Page 1

Work Order ID: 85612

85612

Parent Item: D3396-1

D3396-1

Parent Item Name: Spacer

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.02.23New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR0.750		Purchased	No			100	f	148.6450	0.0625	1.315789			

MDFI RINR0 750

**

Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT055

148.645

116183

2.4

117273

1.555

117322

0.94

*120722

5.28

121783

138.47

1.8815 on 12/07/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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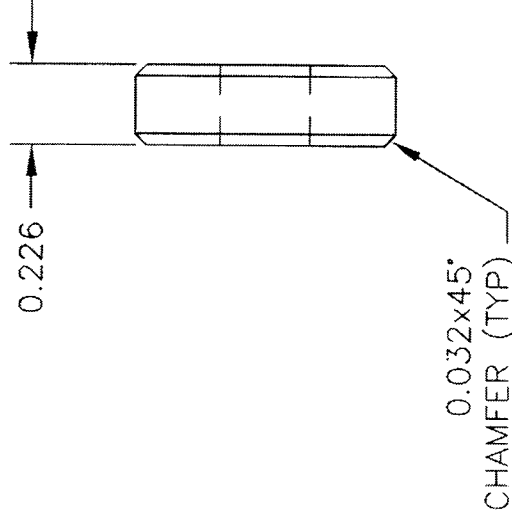
NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CP		CP		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3396		SHEET 1 OF 1	
DATE	TITLE		SCALE		
05.04.27	SPACER		2:1		
A	05.03.10		NEW ISSUE		
B	05.04.27		ADD -3		

05.09.06 *[Signature]*

0.226



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85612 *MW*
12/06/12

DRILL 'F' (Ø0.257 REF, -1 SPACER)
DRILL 'O' (Ø0.316 REF, -3 SPACER)

D3396-1/-3 SPACER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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